

Date: Monday, 12/01/2009 2:36:41 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	GASKET
<b>Job Number</b> :	44648		
<b>Estimate Number</b> :	12714		
<b>P.O. Number</b> :		<b>Part Number</b> :	D353639
<b>This Issue</b> :	12/01/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3536 REV A
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	33966	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	30/01/2009
<b>Written By</b> :		<b>Qty:</b>	12
<b>Checked &amp; Approved By</b> :	JLD 09.01.13	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:A New Issue 07-02-14 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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**Comment:** Qty.: 0.7911 sf(s)/Unit Total : 9.4928 sf(s)

NEOPRENE SHEET 0.063

Batch: 109864 189-1-31

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: A

Prog Rev: A

189-1-31

(12)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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189-1-31

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 0262102 (12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: FD 11

9/2/2

SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 2:36:41 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 44648

Part Number: D353639

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/03 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <u>W4648</u>
<b>Description:</b> Gasket		<b>Part Number:</b> D3536-39
<b>Inspection Dwg:</b> D3536	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/-0.030	35.71	x			
32.78	+/-0.030	32.78	x			
29.28	+/-0.030	29.28	x			
25.78	+/-0.030	25.78	x			
23.25	+/-0.030	23.25	x			
19.75	+/-0.030	19.75	x			
17.75	+/-0.030	17.75	x			
14.25	+/-0.030	14.25	x			
9.50	+/-0.030	9.50	x			
4.75	+/-0.030	4.75	x			
5.00	+/-0.030	5.00	x			
9.00	+/-0.030	9.00	x			
0.30	+/-0.030	.310	x			
0.30	+/-0.030	.311	x			
1.88	+/-0.030	1.885	x			
Ø0.19	+0.005/-0.001	.194	x			
0.063	+/-0.010	.060	x			

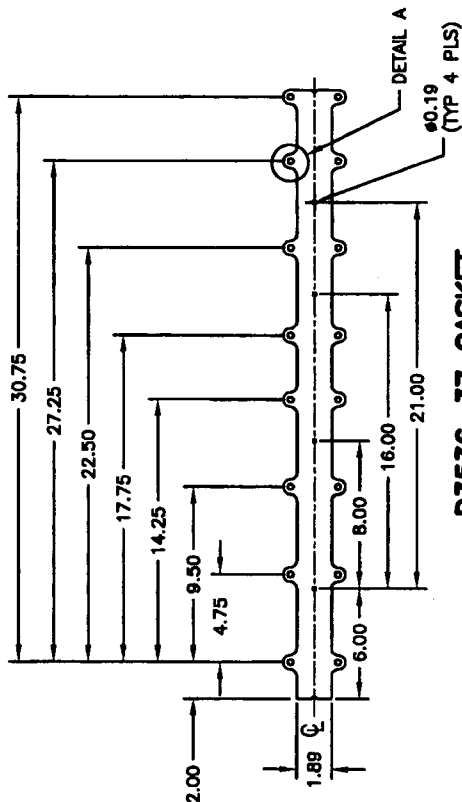
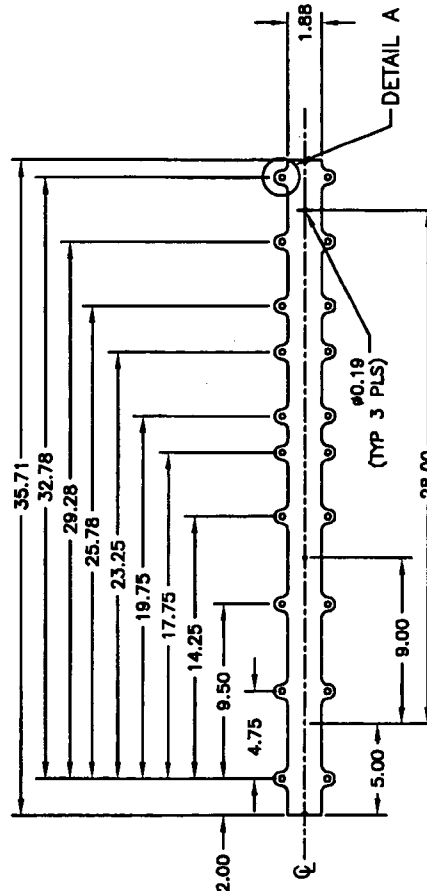
<b>Measured by:</b> <u>IB</u>	<b>Audited by:</b> <u>S</u>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <u>9-1-31</u>	<b>Date:</b> <u>09/02/02</u>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	<u>[Signature]</u>

**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3536</b>	REV. A SHEET 5 OF 6
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>		SCALE <b>1:10</b>

RELEASED  
07.02.12 **[Signature]**

**D3536-37 GASKET****D3536-39 GASKET**

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 80 DUROMETER (REF DART SPEC. M-NE080-S.063)
  - 2) FINISH: NONE
  - 3) PART IS SYMMETRICAL ABOUT  $\phi$
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
  - 7) SEE PAGE 6 FOR DETAILS AND SECTION

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. **44648**

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